

Date: Wednesday, 12/20/2006 1:47:30 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE SPACER
 Job Number : 30055
 Estimate Number : 10827
 P.O. Number : *NIA* Part Number : D2877
 This Issue : 12/20/2006 S.O. No. : *NIA* Drawing Number : D2877 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : *NIA* Type : SMALL /MED FAB Drawing Revision : B
 Previous Run : 28481 Material : *NIA*
 Due Date : 1/2/2007 Qty: 120 Um: Each
 Written By : *JA*
 Checked & Approved By : *JA 061220*
 Comment : Est B 00.05.19 Added inspect level 8 EC
 Est C 06.04.26 Water jet EC
 Est Rev:D Now M6061-T6 06-06-23 JLM
 Est Rev:E Updated Thickness as per Rev B 06-09-18 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.5468 sf(s)/Unit Total : 65.6208 sf(s)

Material: 6061-T6 (QQ-A-250/8) 0.125" Thick

Batch: ~~M18666X~~ ml 07/01/03

120

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2877

Dwg Rev: *B*

Prog Rev: *B*

ml 07/01/03

120

2- Tumble

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



ml 07/01/03



120

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

07/01/04

120

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

Deburr any rough edges after tumbling

SB KLM

9-01-07

Counted
120

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 27/01/12

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SADDLE SPACER

Job Number: 30055

Part Number: D2877

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

WJ Lam

07/01/12 (120)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 7/6/12 (120)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 7/6/12 (120)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/12 (120)

Job Completion



1E

W 07-01-12

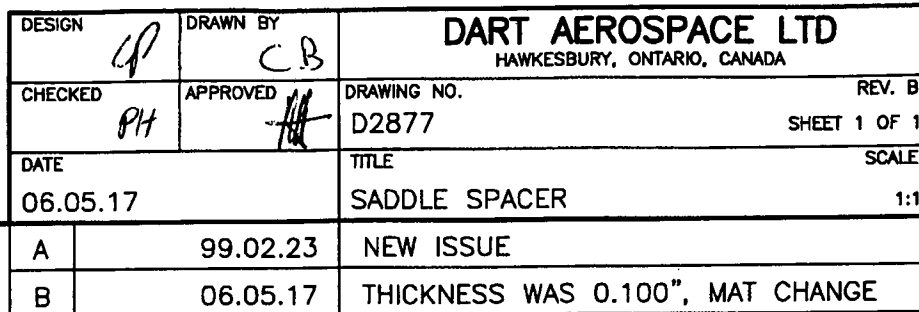
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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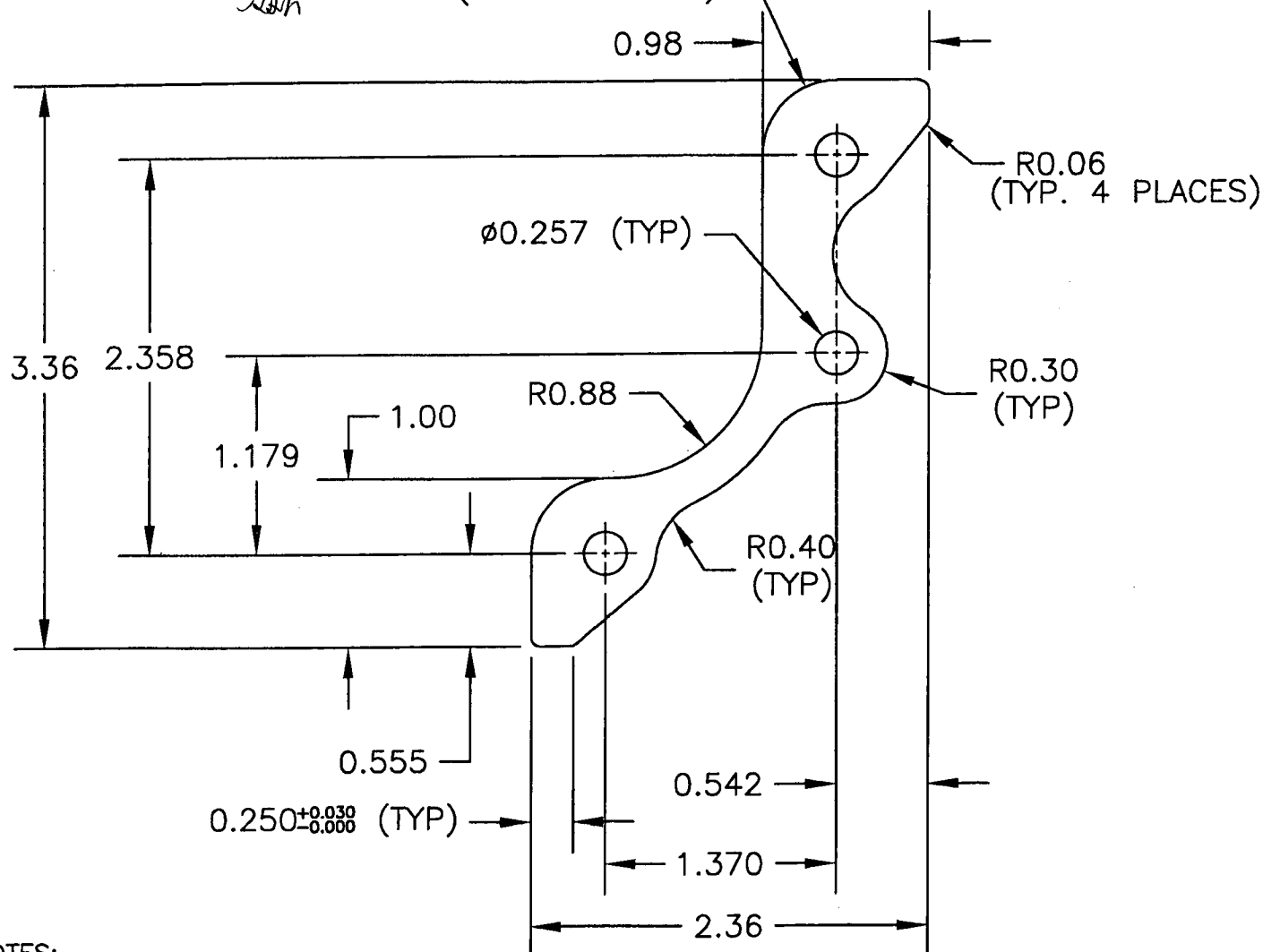
NOTE: Date & initial all entries



RELEASED
06.06.21

AS PER ECN, 813

R0.44 (TYP 2 PLACES)



NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK
(REF DART SPEC M6061T6S.125)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICK
(REF DART SPEC M5052H32S.125)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30055

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